											DQA:	Date	e:	*
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UPDATE		•		-	
		,									QA Closed:	Date	e:	
Work Orde	~					DISPOSITION			AGAINST	DE	PARTMENT/	PROCESS		
WOIK OIU	=1.					Rework	1		Skid-tube Crosstube	,		Water Jet	\neg	Engineering
Part I	No.					Scrap Use-as-is		1	Machining Small Fab		l	d. Eng. Coor. e/Packaging		Quality
NCR f	No.					Work Order Update			Large Fab Composite	`—	Rec/3tor	Supplier		Other
Root					Descri	ption of work order update		nitial	Action		Sign &			
Cause		Date	Step	Qty	·	or Non-conformance	Ch	ief Eng	Description		Date	Verification	1	QC Inspector
Doc/Data														
Equip/Tooling					*.									
Operator								:						
Material			ŀ				٠.		•					
Setup							*							
Other														
Process							ŀ							
Supplier							į							
Training							ļ							
Unapproved														
						F	AUL	T CATE	GORY					
Landi	ng (Gear				General		_			_	_		
		Bending				Bend		Grain		L	Ovalized			Pressure/Forced
		Centre N	ot Concei	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct [Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
	Г	Cuffs				Contamination		Mainte	enance		Part Moved	•		•
		Heat Trea	at			Countersink		Mislabe	eled		Positioned V	Vrong		
		Inspectio	n Strip in	Tube		Cut Too Short	Г	Misread	1		Power Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

V	Vork	Orde	er ID	88	523
₹	V VI K	VIU			JZJ.

Quality Control

August-02-12 1				"885	シスペ								Page 2
Item ID: Revision ID:	D3477-3			Accept	*N90	00	40	100)*	Setup	Start	*N:	S1*
	Tube										Stop	**!	OO*
											•	1/1:	S2*
	7/27/12	Start Qty: 2.00	*2*		Cust Ite	m ID:							
Required Date:	8/24/12	Req'd Qty: 2.00	*2*		Custom	er:							
Reference:			-								_		
Approvals:	Process Pl	an:	Date:	Tooling:		Date:				Run	Start	*NI	R1*
	QC:		Date:	SPC (Y/N):		Date:					Stop	*NI	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool I	D T	ool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
130		QC5- Inspect part complete	ness to step on W/O	0.00									
130													
QC		Memo		0.00									
Quality Control													
										:			
140		Identify as per dwg & Stock	Location:	0.00									
1 <i>4</i> ∩		,		•									
Packaging		Memo.		0.00	. •	•						· · ·	
Packaging					•		,		**				• •
							. 1	* 14		•		`	
								1					7
150		QC21- Final Inspection - W	ork Order Release	0.00					•		*		· •
150													
QC	16 m	Memo		0.00					·		·	•	

114-0123

											DQA:	Date:	1.
NCR:	Yes	/ No				WORK ORDER NON-O	CON	IFORM	MANCE / UPI	DATE		.	
											QA Closed:	Date:	
Work Ord	er:					DISPOSITION	١			AGAINST DE	PARTMENT	PROCESS	
Part I	No					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	otion of work order update	11	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty	•	or Non-conformance	Chi	ef Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator	Ш								•				
Material	Ш								•				
Setup	Ш												
Other	Ш												
Process													
Supplier]								
Training]		ľ								
Unapproved													
						F	AUL	T CATE	GORY				
Landi	ng G	iear				General					_		
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	П	Inspecti	on Incomplete		Part Incorre	ct	Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Wrong Stock Pulled

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

August-02-12 11:49:16 AM

Work Order ID:

88523

Parent Item:

D3477-3

Parent Item Name:

Tube

Start Date: 7/27/12

Required Date: 8/24/12

Start Qty: 2.00

Required Qty: 2.00

IPP Rev. A

New Issue 06-02-07 II M

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S26GA		Purchased	No			100	sf	71.8500	0.19	0.38			Jani

Loc Qty Loc Code Location MAT020 71.85 117798 71.85

122753

127755

NCR:	Yes	/	No

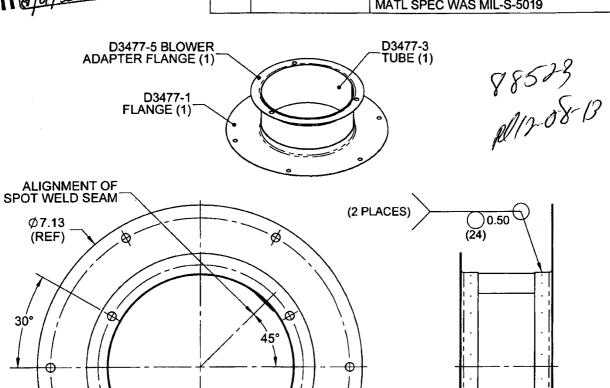
WORK ORDER NON CONFORMANCE / LIDDATE

DQA: _____ Date: _____

NCR: Y	es / No				WORK ORDER NON-	CON	IFUK!	VIAINCE / UP	WATE	QA Closed:	Date	::
Work Orde	r:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N					Rework Scrap		ľ	Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	0				Use-as-is Work Order Update]		noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root				Descri	ption of work order update	lr	nitial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	cription	Date	Verification	QC Inspector
Ooc/Data quip/Tooling												
perator	7											
Material												
Setup												
Other									•			
rocess		1										
Supplier												
raining	7	1										
Jnapproved												
				-	F	AUL	CATE	GORY				
Landin	g Gear				General					_		
	Bending				Bend		Grain		• .	Ovalized		Pressure/Forced
L	Centre N	ot Conce	ntric to O	/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Ш	Inspecti	on Incomplete		Part Incorred	et [Weld
Ĺ	Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat Trea	at		L	Countersink		Mislabe	led		Positioned V	Vrong	
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	Í		Power Loss/	Surge	Other
	Ripples in	n Bend		L	Drill Holes		Offset	*				
	Torque V	Vaves in E	extrusion		Drawing		Out of 0	Calibration				
	Turning S	equence			Finish		Out of S	Sequence				
	Wave/Tu	ist in Tub	20		Folio	$I \square$	Outcido	Dimensions				



	1	L		
DESIGN	A	DRAWN BY	DART AEROSPACE LTE HAWKESBURY, ONTARIO, CANADA	
CHECK	ED	APPROYED	DRAWING NO.	REV. B
P	#		D3477 s _F	HEET 1 OF 4
DATE			TITLE	SCALE
 	08.1	2.19	BLOWER INLET ADAPTER	1:2
Α	0:	5.12.09	NEW ISSUE	
В	0	8.12.19	Ø3.40 & Ø4.1 WERE Ø3.600 & Ø4.14 (SHT 2 & 4); ADD MFG NOTE AND TOL	_ (SHT 3);



D3477-041 BLOWER MOTOR INLET ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE

30°

- 3) IDENTIFY WITH DART P/N D3477-041 USING FINE POINT PERMANENT INK MARKER 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3477-041	BLOWER MOTOR ASSEMBLY
1	D3477-1	FLANGE
1	D3477-3	TUBE
1	D3477-5	BLOWER ADAPTER FLANGE

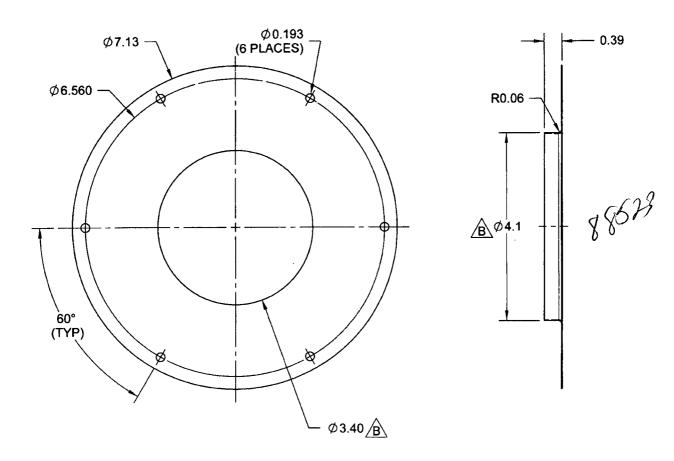
2.04 -

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1			
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DATE		TITLE	SCALE
08.	.12.19	BLOWER INLET ADAPTER	1:2



D3477-1F FLANGE FLAT PATTERN

D3477-1 FLANGE

NOTES:

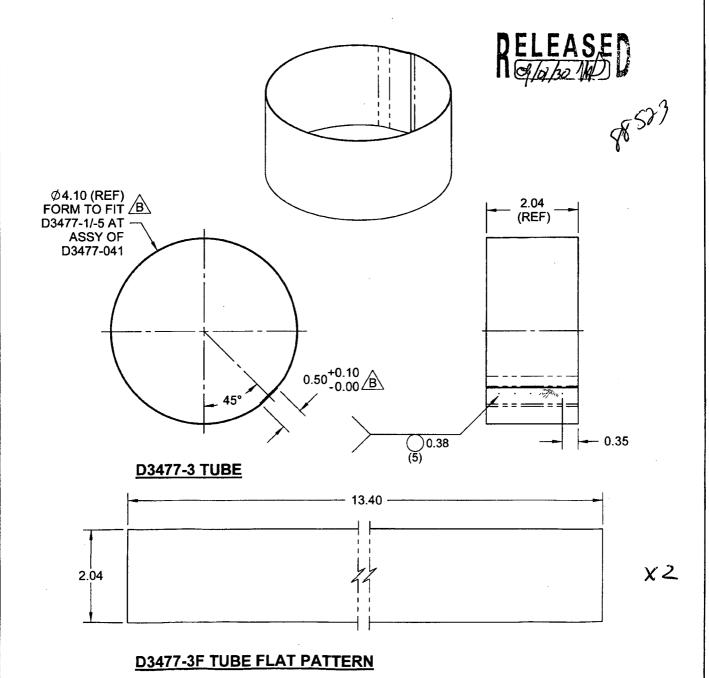
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Per	M	D3477 SH	EET 3 OF 4
DATE		TITLE	SCALE
08	.12.19	BLOWER INLET ADAPTER	1:2



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
 2) WELD PER DART QSI 004
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

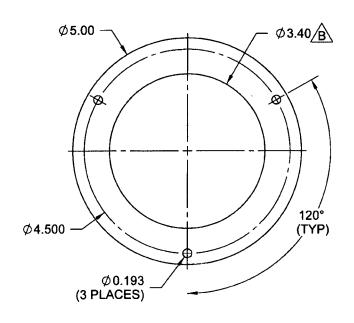
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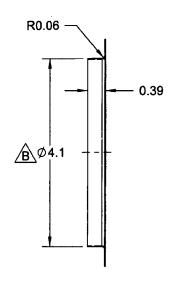
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Pet		D3477 s _H	EET 4 OF 4
DATE		TITLE	SCALE
08	.12.19	BLOWER INLET ADAPTER	1:2







D3477-5F FLAT PATTERN

D3477-5 BLOWER ADAPTER FLANGE

NOTES:

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